

Date: Wednesday, 7/4/2007 4:12:29 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : GPS RECEIVER HOUSING

Job Number : 33307

Estimate Number : 12492

P.O. Number : N/A

This Issue : 7/4/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : SMALL / MED FAB

Previous Run : 32536

Written By : *[Signature]*Checked & Approved By : *[Signature]*

Comment : Est Rev:A New Issue 06-07-26 JLM

Part Number : D35143

Drawing Number : UNDER REVIEW

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 7/11/2007

Qty: 1 Um: Each

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.4812 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M-463321

IB 07-07-06

CERTIFICATE OF CONFORMITY
REQUIRED

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: PREL

Prog Rev: PREL

Ensure Grain Direction is correct**

2-Deburr if necessary

IB 07-07-06

MF 07-07-09

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-07-06

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En

07/07/10

XL

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink as per Dwg D3514




MF

07-07-10.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/10
 QA: N/C Closed: _____ Date: _____

NCR: <u>33307</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/10	# 2.0	1 Part scrap wrong mat used (0.050" instead of 0.040") R.C. Human Error		- Scrap and replace with correct correct mat. - Remind Employee to be more cautious when pulling mat. - BATCH # <u>M102723</u>	07-07-10 ES	En 07/07/10		En 07/07/10
				M100742 				

NOTE: Date & initial all entries

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6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/10

①

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB 07/07/10

①

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FAI NEEDS MORE
DIMS.
CB 07.07.11

**ENGINEERING
APPROVAL**

07/07/10

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A
E

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1 PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

07.07.19

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.19

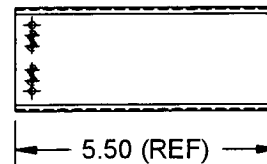
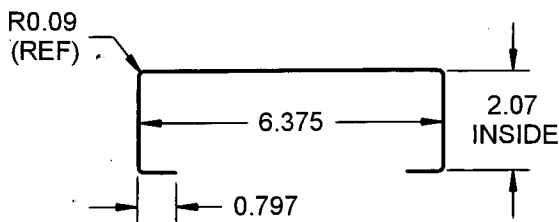
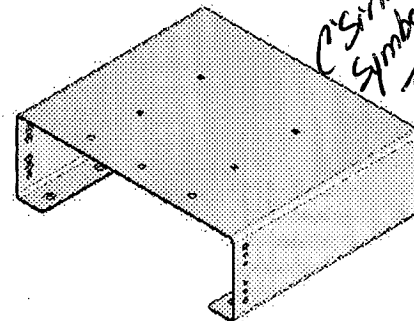
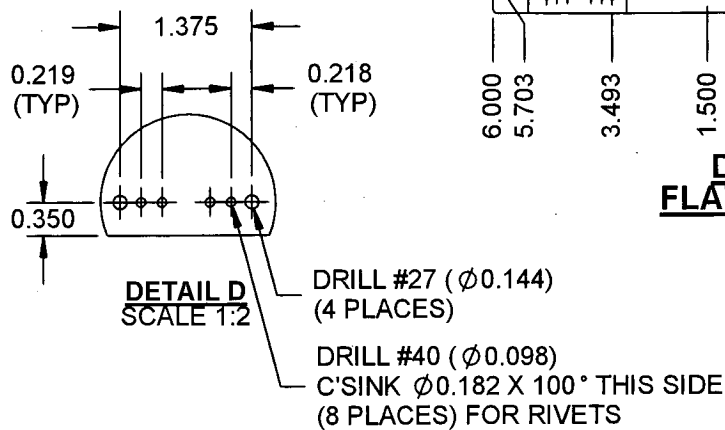
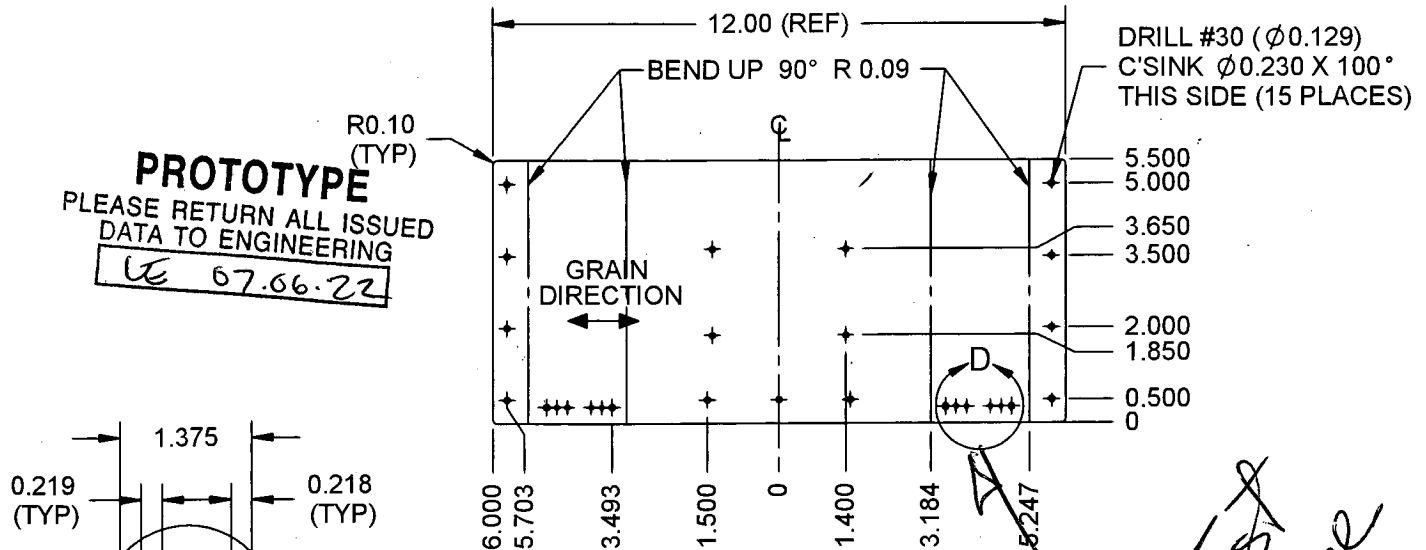
Job Completion



07/07/10

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3514	REV. A SHEET 6 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:4

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 67.66.22



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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Receiving Report

Date: April 21/06
Supplier: Copper & Brass

Batch No: 1100742
Dart P/O: 1005

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☐
Shipment Complete: Yes ☐ No ☒
Q.C. Inspection ☐

Discrepancies		Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
Part No	Description					
M505243	5090 Sheet	96	0	0	96	
M6061T6B	250 X 06000	48	0	0	48	
M6061T6B	0500 X 0250	12	10	0	2	

TSR No: _____

Initials of receiver (if shipment OK) [Signature]

Production/Admin:

Date:

Received/Costing:

Initial:

H:\090001\Forms\Purchase\RECREPORT rev B

Accounting:

Date:

AP/MR:

Initial:


DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
PLEASE REMIT IN CANADIAN FUNDS		GST/HST		9.66
TOTAL \$				147.73

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH. PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

70294	SHIP DATE 04/24/06 SHP	GROSS WEIGHT	QUOTE 30-161074-1	0 OF 10 PACKING LIST	
ART AEROSPACE		WORK ORDER **	ORDER DATE 04/13/06 ORD	TEST RESULTS	
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA K6A 1K7		DELIVERY DATE 04/24/06 DEL	SHIP BRANCH 30 (04)	SELL BRANCH 30-TOR	WORK ORDER UZ3809
6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y		Copper and Brass Sales Canada  A ThyssenKrupp Materials NA company ThyssenKrupp			
NUMBER 20 NUMBER 000001005	TERRITORY 01	ENTRY ID 30BXT	CUSTOMER SIGNATURE: _____ DATE: _____		
INDA LACELLE	INSIDE SALES BRIAN TEDESCO	QUANTITY	ORDERED	SHIPPED	
TELEPHONE (513) 632-9577	INSIDE SALES TELEPHONE (905) 696-8100 37622	INVENTORY	54.19 LB	52.00	
SHIP VIA	SHIPPING STATUS	BILLING	2.00 PC	2.00	
COMPLETE X	PARTIAL	CANCEL	WAREHOUSE		
CUSTOMER COMMON/FRT-CCX	FOB DEST	PACKED WITH OTHER GOODS UZ3800		FINISHED GOODS LOCATION WARN LABEL:1001	
PREPENDING	PREPENDING			063496-4	

PART DESCRIPTION

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 ART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 dimensions., Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

Rec'd 4/24

SPECIAL INSTRUCTIONS									
Shipping, do not place any packages or goods on top of our material."									
SCRAP	FILLED BY SC		PACKED BY		Q/A AUDIT				
MAX SKID WEIGHT 100	LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK				MAXIMUM BUNDLE WEIGHT 200				
PKGS	SKIDS	BOLS	TUBES	CTNS	FLAT	COILS			
INSPECTION RECORD									

TEST RESULTS -----

CERTIFICATE OF COMPLIANCE
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 244-233-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027 ASTM-B209
 ROHS COMPLIANT

QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS ! TAG NO	QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS
52.00 LB CORUS	0CC1837 7124901	!			